

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009296**Date Inspected:** 21-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

| | | | | | | | |
|------------------------------------|---------------------------------|----|-----|----------------------------------|------------------|----|-----|
| CWI Name: | Yu Dong Ping, Chen Ying Xin, Li | | | CWI Present: | Yes | No | |
| Inspected CWI report: | Yes | No | N/A | Rod Oven in Use: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A | Weld Procedures Followed: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A | Verified Joint Fit-up: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A | Approved WPS: | Yes | No | N/A |
| | | | | Delayed / Cancelled: | Yes | No | N/A |
| Bridge No: | 34-0006 | | | Component: | Tower Components | | |

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay10, North Tower.

SAW welding of weld joint ND1-A112A/H-1A; located on Bay10, North Tower. Welder is identified as 052917; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2221-B-U3C-S-2.

Bay11, West Tower.

SMAW Repair welding of weld joint WD1-A6001-3-8A/B; located on Bay11, West Tower. Welder is identified as 040704; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-2G(2F)-REPAIR.

Bay11, North Tower.

FCAW welding of weld joint NSD1-A803B/B-1-1; located on Bay11, North Tower. Welder is identified as 070397; ZPMC Quality Control Inspector (QC) is identified as Liu Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2131.

Bay11, East Tower, Corner angle Plate.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW Repair welding of weld joint ESD1-SA183-47.6M-2-1A/B (WRR # T-WR2184); located on Bay11, East Tower. Welder is identified as 040656; ZPMC Quality Control Inspector (QC) is identified as Xu Le Feng. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-1G(1F)-FCM-REPAIR-1.

Tower Jetty(Heavy Dock), South Shaft, Lift 1, Skin A.

- 1) Installation of External Splice Plate.
- 2) Drilling holes on Doubler Plate between 18M & 47.6M Doubler Plate.

Tower Jetty(Heavy Dock), East Shaft, Lift 1.

Repair Welding & Grinding on Suport Brackets inside tower.

Bay 10, North tower, Corner seam(OUT SIDE).

FCAW Repair welding of weld joint NSTL3-3B/K-83B; located on Bay 10, North tower. Welder is identified as 040261; ZPMC Quality Control Inspector (QC) is identified as Du Zhiquan. The welding variables recorded by Quality Control Inspector (QC) NOT appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-REPAIR.

During random Inprogress Inspection This QA inspector observed that welding going on over maximum Interpass Temperature at Repair spot on Weld joint identified as NSTL3-3B/K-83B. When QA marked on the area adjacent to the weld with temprature Crayons; temperature found to be over 230`C(Max. Interpass Temperature).

This QA Inspector have written Incident Report on this issue on this date.

This QA Inspector carried out NDE on following:

Tower Jetty(Heavy Dock), East Tower, Lift 2, Padeyes.

This QA inspector did not performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of area Notified by ZPMC (Notification # 004256), FOR GREEN TAG. Since it was raining out side & Inspection area was wet.

Bay 10, South Tower, Lift 3, SkinC, Fit lug.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as SSTL3-1G/K-102.

This notification is incomplete. there was no access to other two Items of this Notification(004260).ZPMC agreed to renotify the notification.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

| | | |
|----------------------|------------------|-----------------------------|
| Inspected By: | Juvekar,Amit | Quality Assurance Inspector |
| Reviewed By: | Clifford,William | QA Reviewer |
